

Date: Thursday, 08/05/2008 12:36:55 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HELI UTILITY BASKET LH/RH 350/355
Job Number :	39131		
Estimate Number :	10208		
P.O. Number :		Part Number :	D350607043
This Issue :	08/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D350-607 REV F P7-9
First Issue :	08/05/2008	Project Number :	N/A
Previous Run :	39050	Drawing Revision :	F
		Material :	
Written By :		Due Date :	24/05/2008
		Qty:	1 Um: Each
Checked & Approved By :	<u>JLD 08.5.08</u>		
Comment :	Est Rev:E as Per DS19318 06-01-24 JLM Est Rev:F ECN1068 07-12-21 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPPD350-607-043 CHG004

JLD 08.5.12
086666

2.0	39131A	BASKET LID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component BASKET LID ASSEMBLY
 D2989-041 B *39131A*

08/05/06

3.0	39131B	BASKET LID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component BASKET LID ASSEMBLY
 D2989-043 B *39131B*

08/05/30

4.0	39131C	BASKET BASE ASSEMBLY (350)
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Comment: Sub-Component BASKET BASE ASSEMBLY (350)
 D2221 B *39131C*

08/05/30

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick: Assembly Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 12:36:55 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39131

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

NAS1515H4

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 NAS1515H4 WASHER 1106919

7.0

D2022101

Spacer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

5 D2022-101 Spacer 33985

8.0

D2258200

Placard 200lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2258-200 Label 32848

9.0

D2332041

Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y 38597

10.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment 37546

11.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring 37071

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39131

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2537

Bushing

37605

JS 08/05/29 (41)

13.0

D27283

Dart Logo Label - large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2728-3

Label

B22553

JS 08/05/29 (41)

14.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2931

Bumper

21139

JS 08/05/29 (41)

15.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

M100815

JS 08/05/29 (41)

16.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-13A

Bolt

M107534

JS 08/05/29 (41)

17.0

AN422A

Bolt



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

7 AN4-22A

Bolt

M104937

JS 08/05/29 (41)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39131

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

M107939

JS 08/05/29 (4)

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer

M107091

JS 08/05/29 (4)

20.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

14 AN960JD416

Washer

M107939

JS 08/05/29 (4)

21.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416L

Washer

M107008

JS 08/05/29 (4)

22.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer

M107534

JS 08/05/29 (4)

23.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer

M107715

JS 08/05/29 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39131

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet

M18071

JS 08/05/2008

25.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

M107644

JS 08/05/2008

26.0

MS21042L4

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

9 MS21042L4 Nut (or -4)

M107478

JS 08/05/2008

27.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5)

M107464

JS 08/05/2008

28.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

Seal Support Gusset with Sikaflex -291

Batch: M107864

Exp Date: 10/2008

CP 08/06/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39131

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/06

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

31.0

D22301

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

38919 39315

08/05/05

32.0

D22303

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

38532

08/05/29 (X1)

33.0

D23241

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 *D2324-1

Strut Ass'y

36749

08/05/29 (X1)

34.0

D2732

Rubber Extrusion



Comment: Qty.: 2.0000 f(s)/Unit Total : 2.0000 f(s)

Rubber Extrusion

8x D2732-030 -(cut to 3")

Batch:

37632

08/05/29 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39131

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN412A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M105143

JS 08/05/29 (X)

36.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-13A

Bolt

M107534

JS 08/05/29 (X)

37.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch:

M107321

JS 08/05/29 (X)

38.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

M107939

JS 08/05/29 (X)

39.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

M107478

JS 08/05/29 (X)

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/06/06 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 12:36:55 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 39131

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-043

Location: _____

Ref 1570

42.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-06-06
62

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

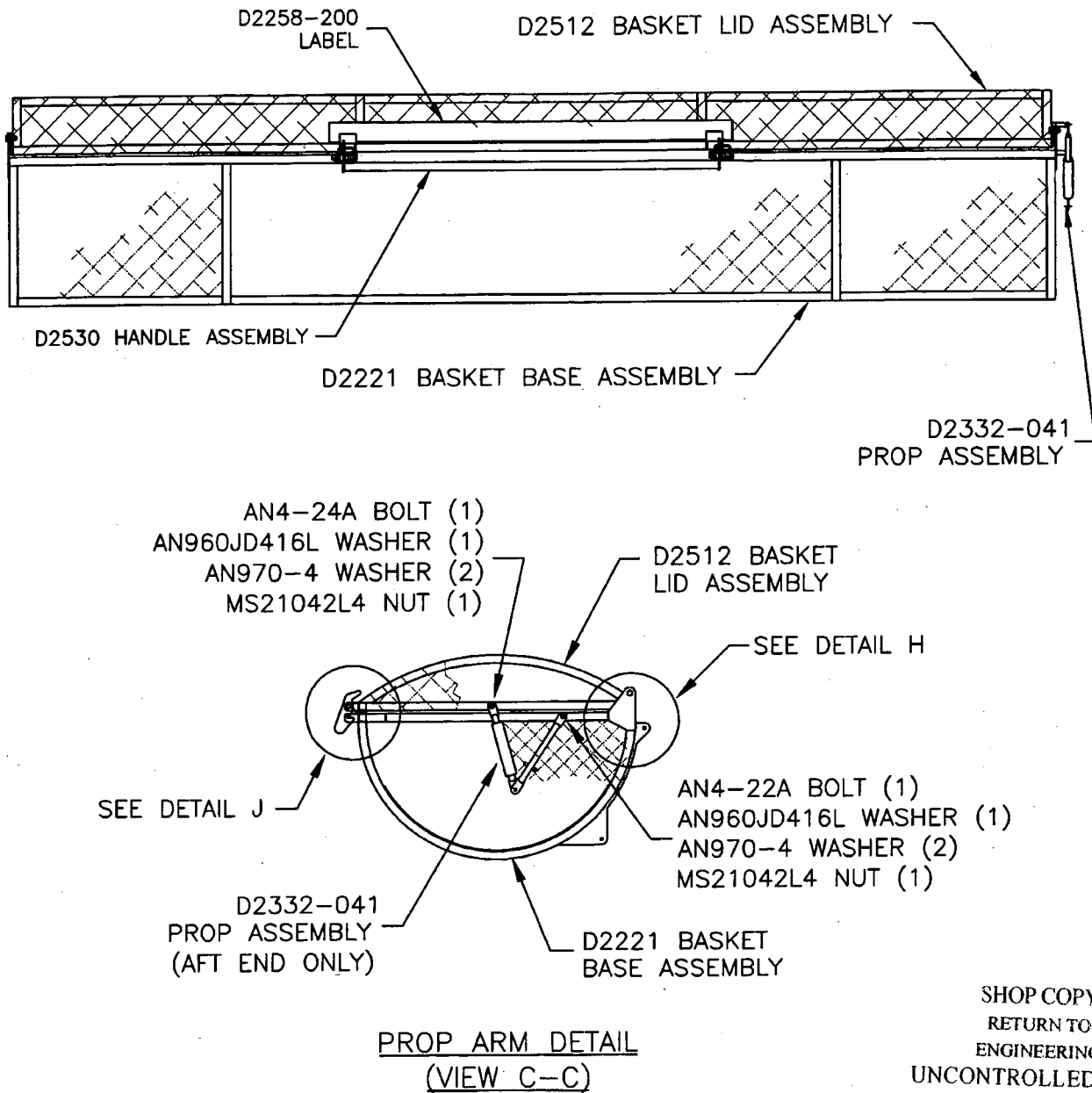


Figure 4 - Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)

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WITHOUT NOTICE
WORK ORDER
NO. 39131

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Revision: F
Date: 03.01.17

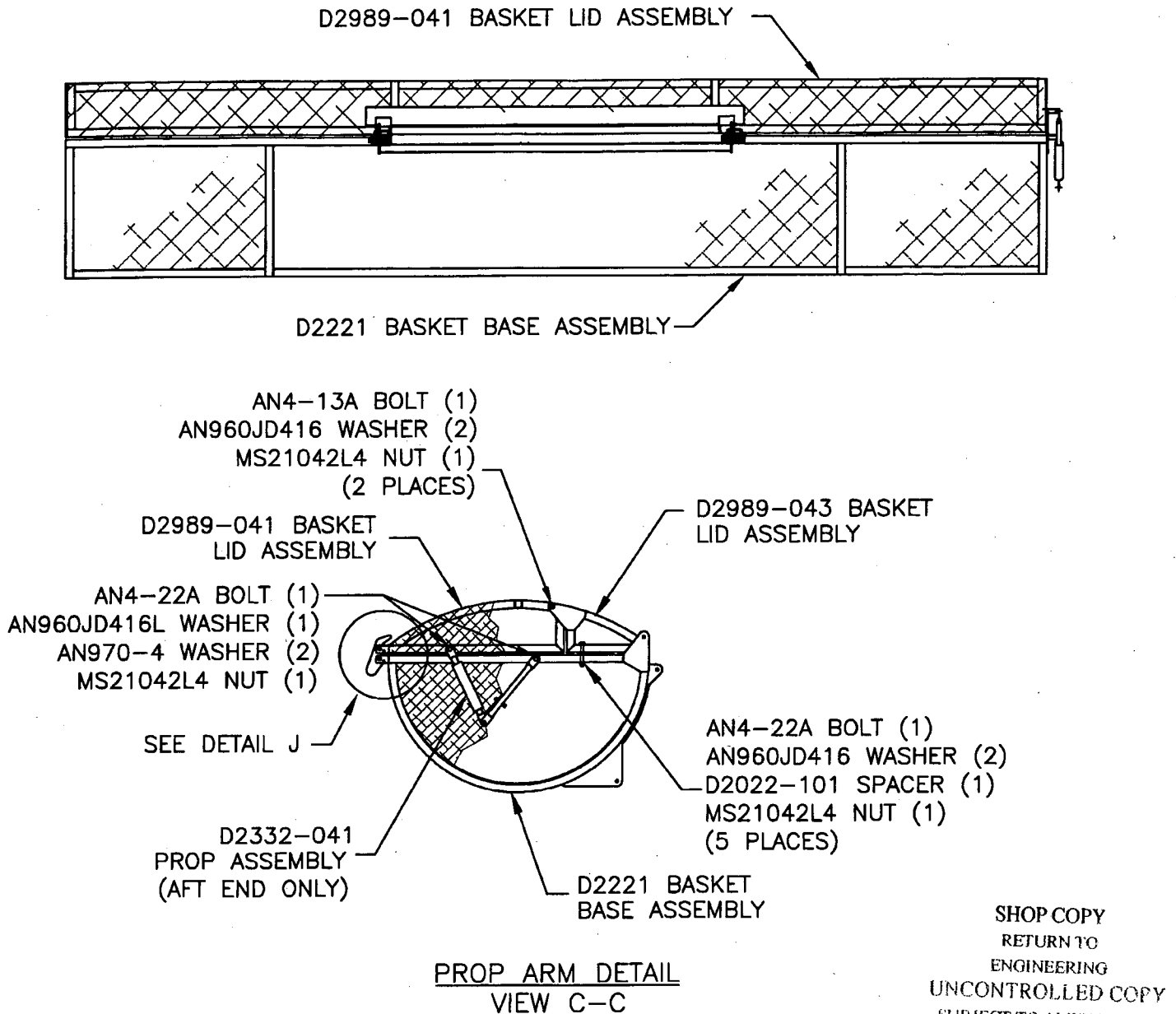
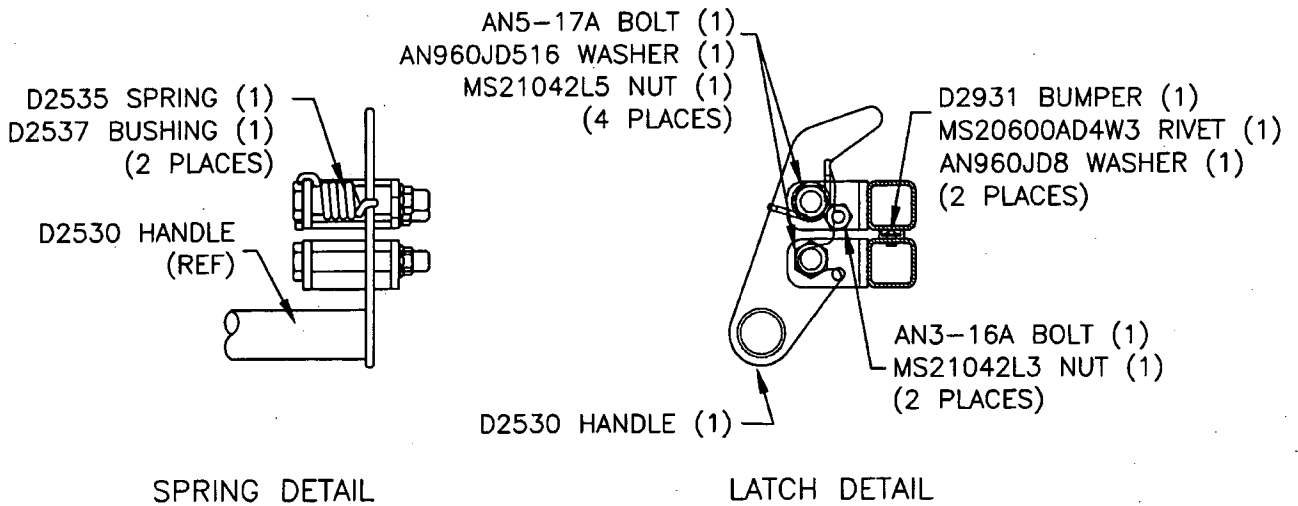


Figure 5- Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)

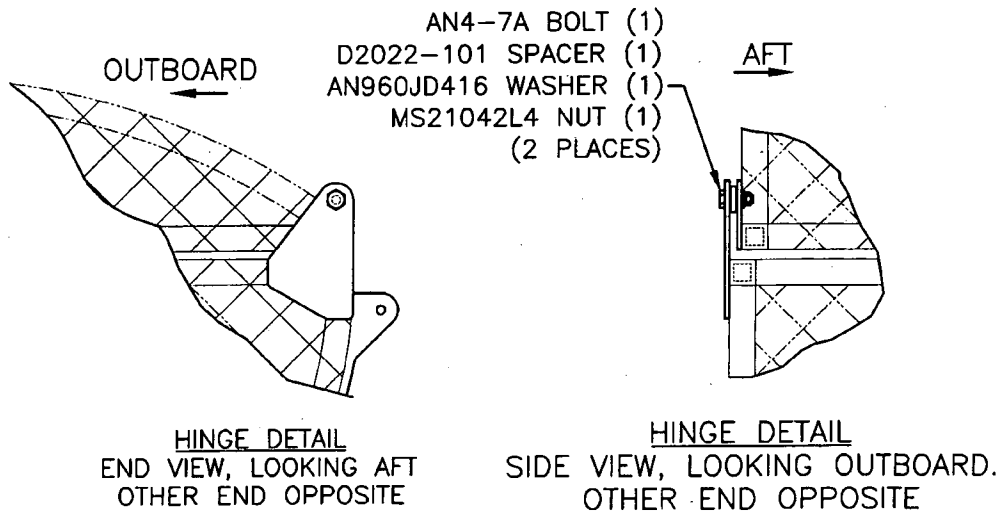
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Revision: **F**
Date: 03.01.17



DETAIL J:
HANDLE WELDMENT



DETAIL H:
HINGE

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Figure 6 – Basket Replacement Parts

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-607-041/-043 (LH installation)	88 lb 39.9 kg	- 48 in - 1.22 m	- 4224 in-lb - 48.7 m-kG	135 in 3.43 m	-11880 in-lb -136.9 m-kG
D350-607-041/-043 (RH installation)	88 lb 39.9 kg	+ 48 in + 1.22 m	+ 4224 in-lb + 48.7 m-kG	135 in 3.43 m	11880 in-lb 136.9 m-kG

5. PARTS LIST

Qty -041	Qty -043	Part Number	Description
X		D350-607-041	HELI-UTILITY-BASKET
	X	D350-607-043	HELI-UTILITY-BASKET
2	5	D2022-101	SPACER
1	1	D2221	BASKET BASE ASSEMBLY
4	4	D2230-1	LUG
4	4	D2230-3	CLAMP
1	1	D2258-200	LABEL
1	1	D2324	STRUT
1	1	D2332-041	PROP ASSEMBLY
1		D2512	BASKET LID ASSEMBLY
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
4	4	D2856-400-720	ABRASION STRIP
2	2	D2931	BUMPER
	1	D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	1	D2989-043	BASKET LID ASSEMBLY (INSIDE)
2	2	AN3-16A	BOLT
2		AN4-7A	BOLT
5	5	AN4-12A	BOLT
8	10	AN4-13A	BOLT
1	7	AN4-22A	BOLT
1		AN4-24A	BOLT
4	4	AN5-17A	BOLT
2	2	MS20600AD4W3	RIVET (OR CR9163-4-3)
28	40	AN960JD416	WASHER
2	2	AN960JD416L	WASHER
4	4	AN960JD516	WASHER
2	2	AN960JD8	WASHER
4	4	AN970-4	WASHER
2	2	MS21042L3	NUT (OR MS21042-3)
17	22	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

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WORK ORDER
NO. 39/3/



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9318	REV. A SHEET 1 OF 1
DATE 06.01.06		TITLE WASHER ADDITION	SCALE NTS
A	06.01.06	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

REF. FAA STC: SR00213NY

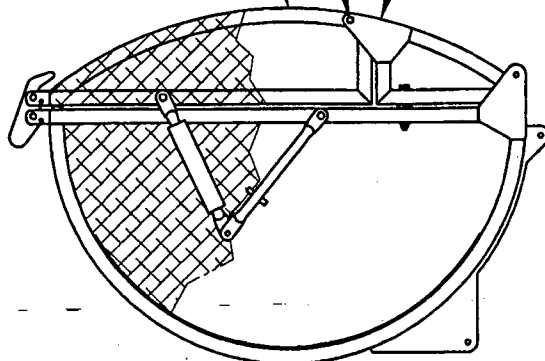
To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047 Heli-Utility-Basket**.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:

AN4-13A BOLT (1)
AN960JD416 WASHER (1)
HINGE PLATE (REF)
NAS1515H4 WASHER (1)
BASKET FRAME (REF)
AN960JD416 WASHER (1)
MS21042L4 NUT (1)
(2 PLACES)

BASKET FRAME (REF)

HINGE PLATE (REF)



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NO. 39137

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE #02)

DATE: 06.01.06
CERT. NO.: SH94-14
ISSUE NO.: 4

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Date: Thursday, 08/05/2008 12:37:07 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 39131B		
Estimate Number	: 10207		
P.O. Number	:	Part Number	: D2989043 <i>RA 08.05.03</i>
This Issue	: 08/05/2008 S.O. No. :	Drawing Number	: D2989 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 08/05/2008 Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 39050B	Material	:
Written By	:	Due Date	: 24/05/2008 Qty: 1 Um: Each
Checked & Approved By	: <i>JLD 08.05.08</i>		
Comment	: Est Rev:l Removed D2989-041 05-11-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3182-1

Hinge

B36483 → 1x B39336 → 1x
JLD 08/05/27

2.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3442-3

Shim

B37160
JLD 08/05/27

3.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)

Pick:

Qty Part number Description Batch

8sf M304EX0.75-16F Expanded Metal

M107856
SAD 02/05/23
(1)

4.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.065" wall 304/316 SS tubing.

Batch: *M107857*
SAD 02/05/23
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 12:37:08 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET.LID ASSEMBLY

Job Number: 39131B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

SAD

08/05/23 ①

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

JS 08/05/28

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-05-29 ①

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 08-05-29 ①

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1 COAT

805

700°

835

2 COAT

900

700°

9:30

BR 08-05-30 ①

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

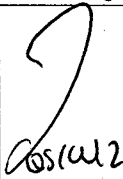
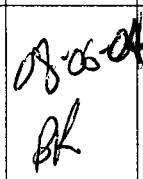
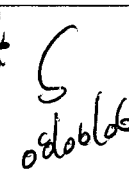
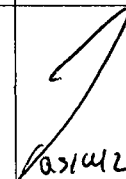
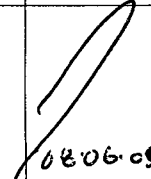
08/05/30 ②

PD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2989-043 PAR #: N/A Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/06/05
 QA: N/C Closed: _____ Date: _____

NCR: 39131B		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080604	7.0	Upon Assembly it was found that the lid had to be tweaked to fit the base with the other -041 Lido. This damaged the Powder coat. R.C. Slight twisting from welding + Mesh.	 08/06/04	- Re. powder coat as per Q31005 START 3:15 TEMP. 400° FINISH 3:45	 08/06/04	 08/06/04	 08/06/04	 08/06/04

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 12:37:08 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BASKET-LID ASSEMBLY

Job Number: 39131B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/09 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



cmf 08-06-06
CL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED05.08.19 *[Signature]***PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

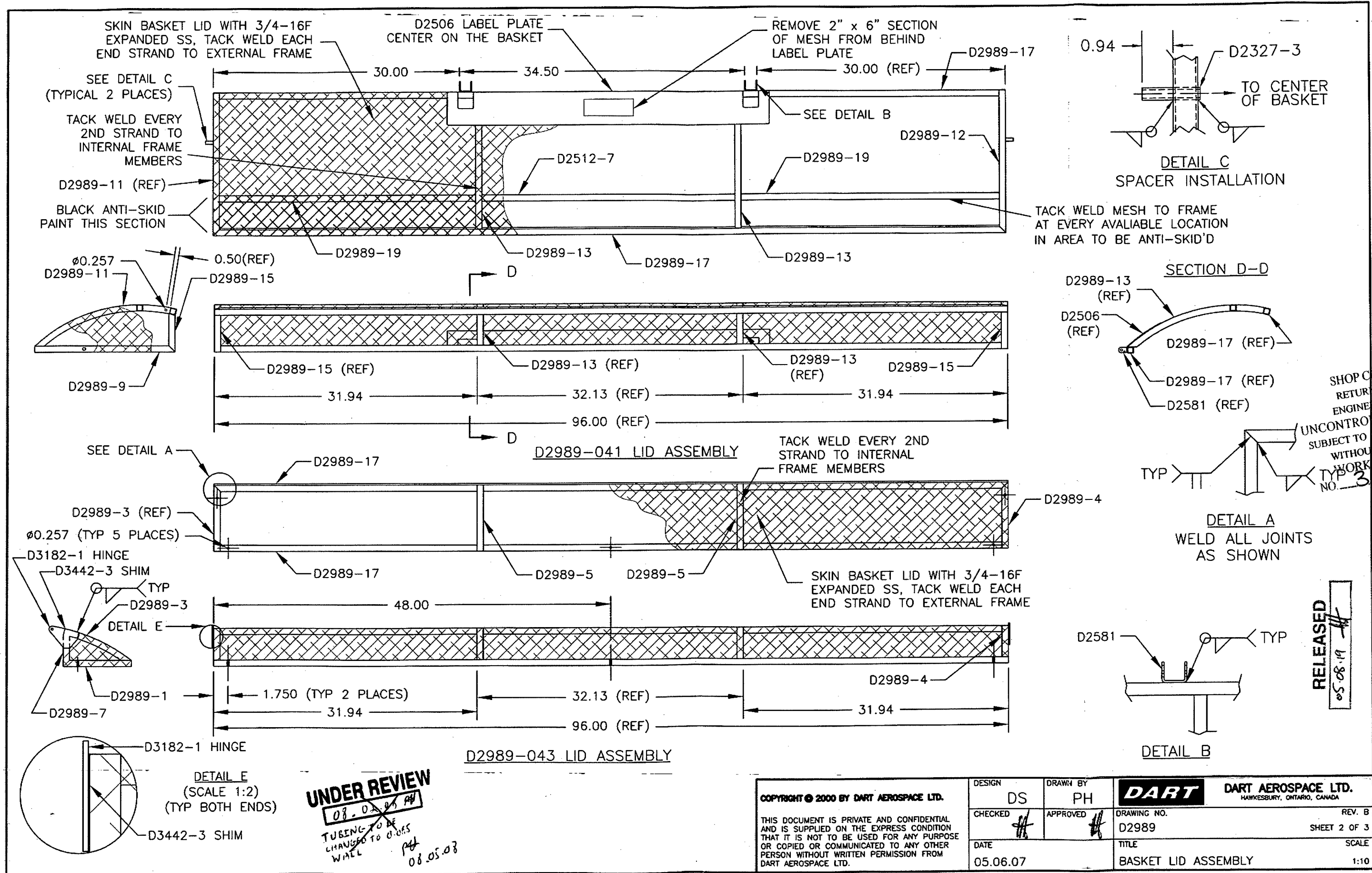
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT—
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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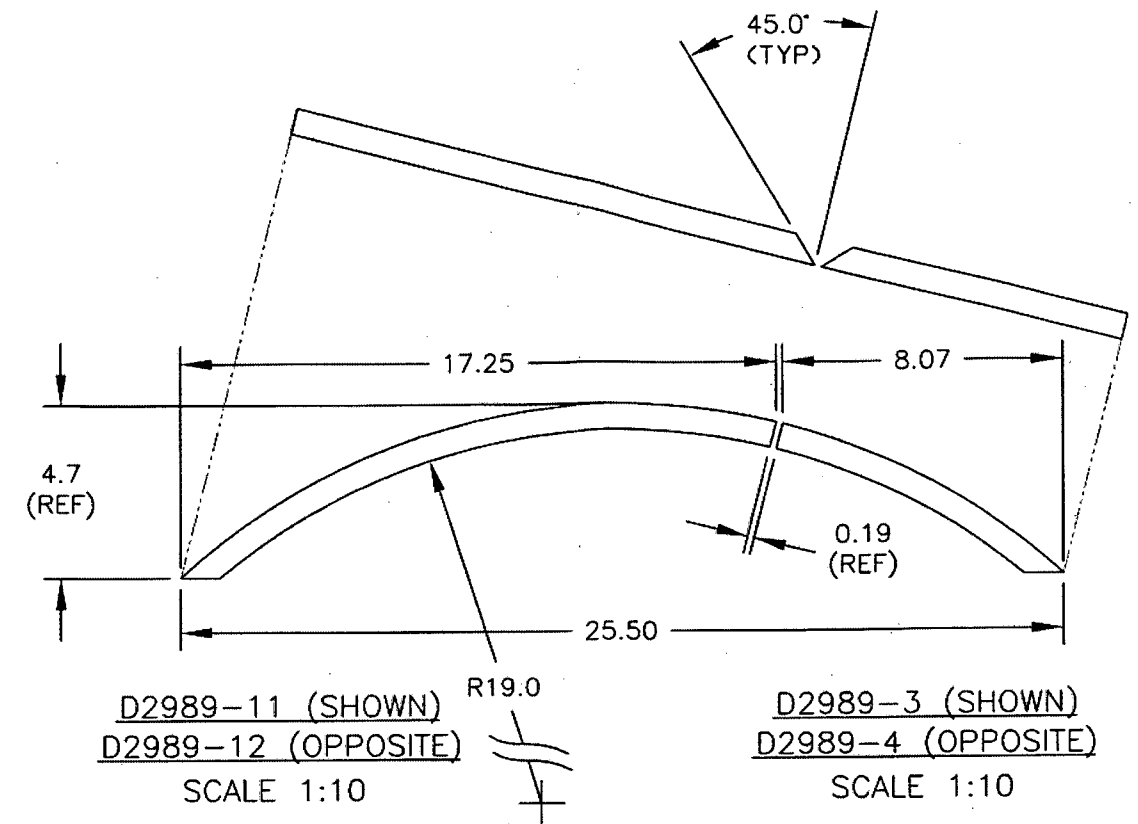
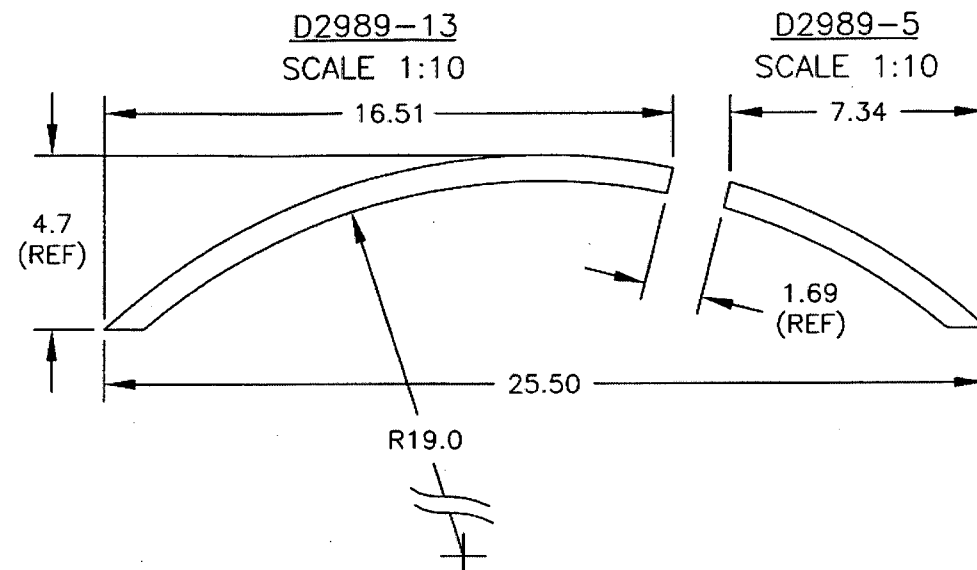
UNDER REVIEW08.05.08
TUBING TO BE
CHANGED TO 0.065
WALL
PHSHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 391318



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39131B

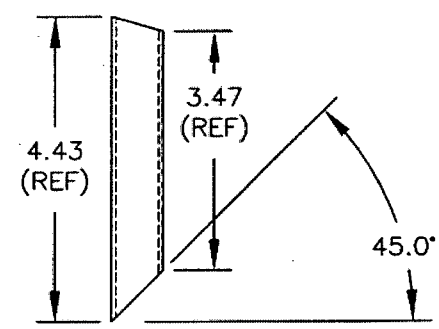
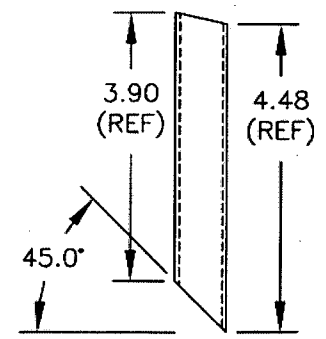
RELEASED
05.08.19

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		CHECKED	APPROVED	D2989	SHEET 2 OF 3
		DATE		TITLE	SCALE
		05.06.07		BASKET LID ASSEMBLY	1:10

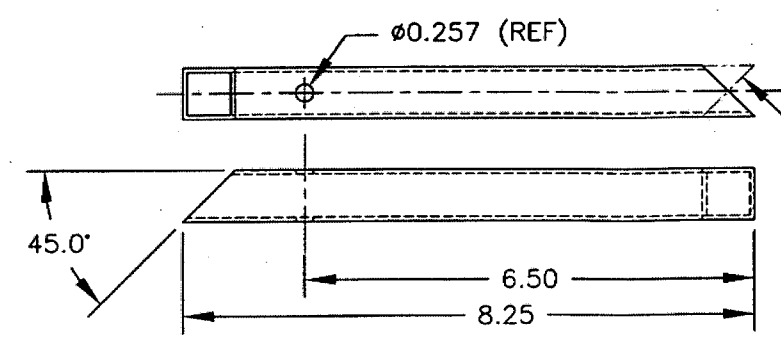


D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-1 (SHOWN)
D2989-2 (OPPOSITE)
SCALE 2:5

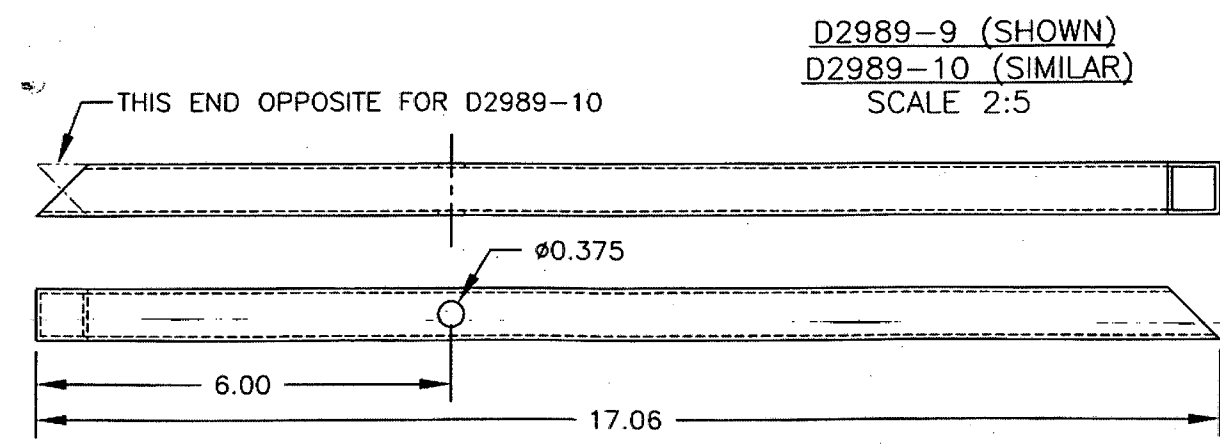


08.05.08
UNDER REVIEW
08.08.08 PH
TUBING TO BE
CHANGED TO 1/8" O.D.
WALL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 371318

THIS END OPPOSITE
FOR D2989-2

RELEASED
05.08.19



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DATE 05.06.07		TITLE BASKET LID ASSEMBLY		SCALE 1:10	

Date: Thursday, 08/05/2008 12:37:02 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET LID ASSEMBLY
Job Number :	39131A		
Estimate Number :	10206		
P.O. Number :		Part Number :	D2989041 <i>pt 08.05.08</i>
This Issue :	08/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2989 UNDER REVIEW
First Issue :	08/05/2008	Project Number :	N/A
Previous Run :	39050A	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<i>JLD 08.508</i>	Due Date :	24/05/2008
Comment :	Est Rev: Removed D2989-043 05-11-03 JLM	Qty:	1
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty.(1) D3166-3 Batch: *38780**SAD**08/05/22**①*

2.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2581 Mounting Brackets *B37248**ls**08/05/27*

3.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2327-3 Bushing *B37541**ls**08/05/27*

4.0	D2506	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2506 Label Plate *B37446**ls**08/05/27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2023 12:37:03 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 39131A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

Qty Part number

Description Batch

15sf M304EX0.75-16F

Expanded Metal

M107856

SAD

08/05/23

(R)

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: M107857

SAD

08/05/23

Q

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

SAD

08/05/23

(P)

2-Drill holes in tubing as D2989-041 per Dwg D2989 ✓

3-Deburr and remove all markings on material ✓

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required ✓

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid ✓

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041 ✓

08/05/23

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/05/23

9.0

QC5

INSPECT WORK TO CURRENT STEP



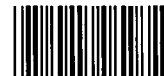
Comment: INSPECT WORK TO CURRENT STEP

08/05/23

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

08-05-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2989-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 08/06/09
 QA: N/C Closed: _____ Date: _____

NCR: <u>39131A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080604	9.0	Upon Assembly it was found that the lid had to be tweaked to fit the base; - 043 lid. This damaged the powder coat R.C: Slight twisting from welding + mesh.	<i>[Signature]</i>	re-powdercoat per Q51005 START 3:15 TEMP 400° FINISH 3:45 <i>[Signature]</i>	080604 <i>[Signature]</i>	<i>[Signature]</i> 080606	<i>[Signature]</i>	080604

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 12:37:03 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 39131A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: *M 108/23*

Wing Walk: *M 107892*

br 08-06-02

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

EP 08/06/02

12.0

QC21

FINAL INSPECTION W/O RELEASE



08/06/09

Comment: FINAL INSPECTION W/O RELEASE

Job Completion



MF 08-06-06
CL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED05.08.19 *[Signature]***PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

UNDER REVIEW08.02.05 PH
TUBING TO BE
CHANGED TO 0.065
WALL
PH
08.05.07SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENTWITHOUT NOTICE.
WORK ORDER

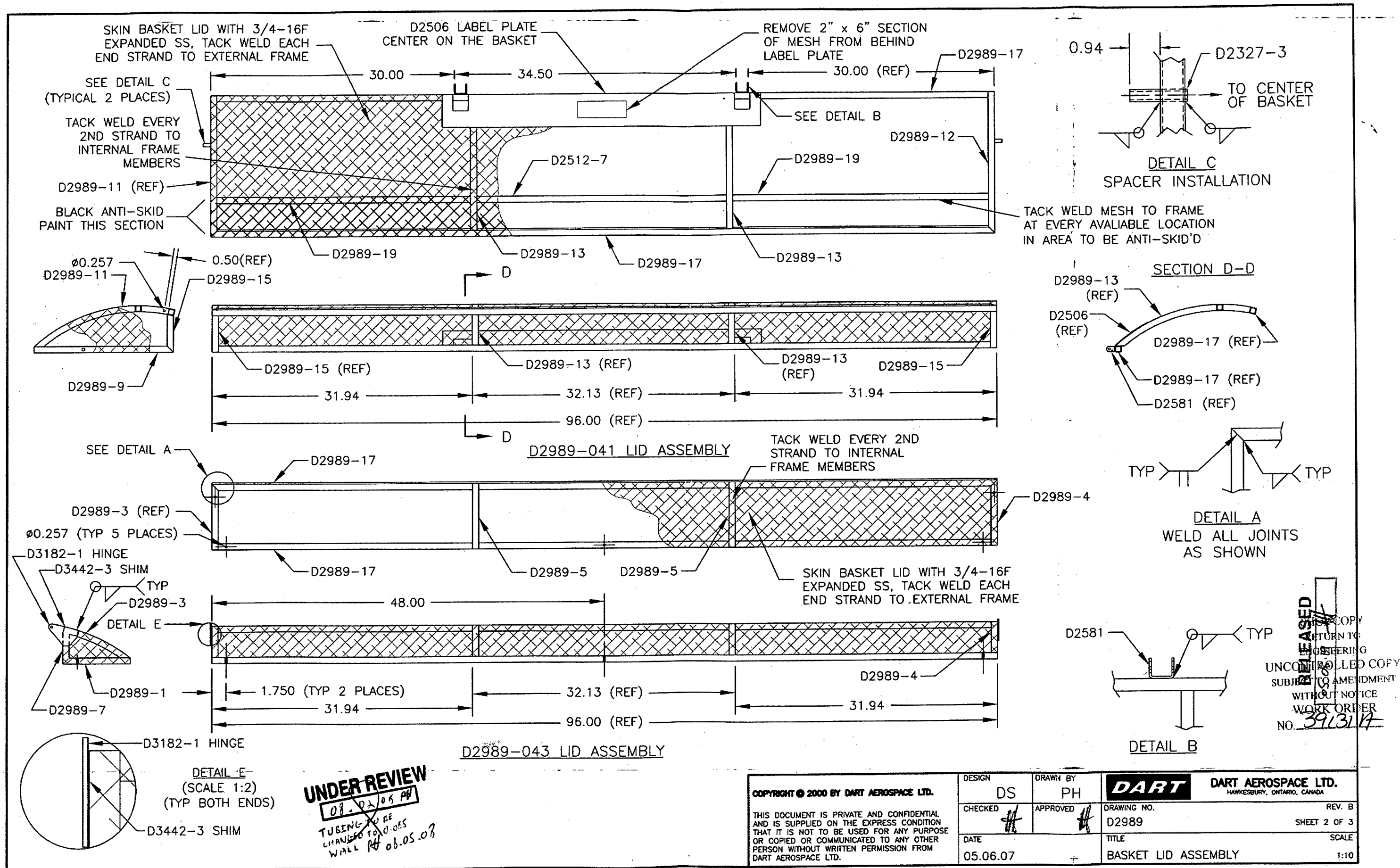
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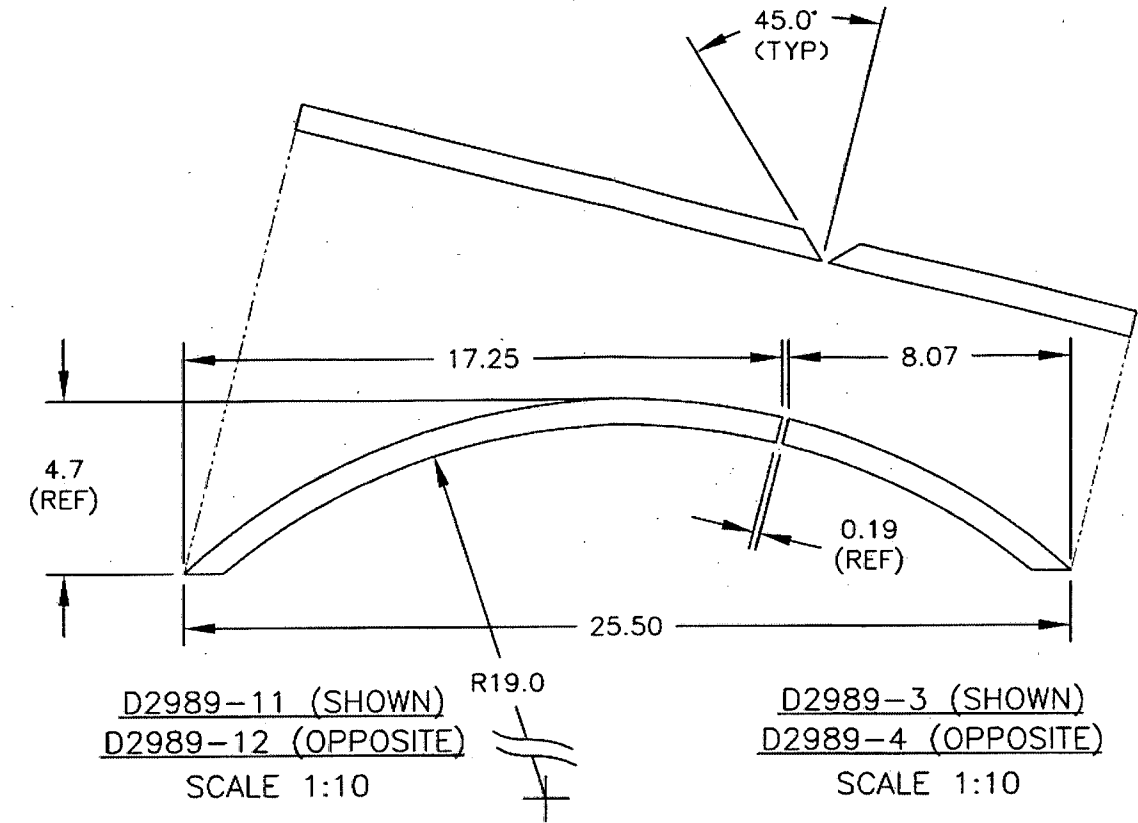
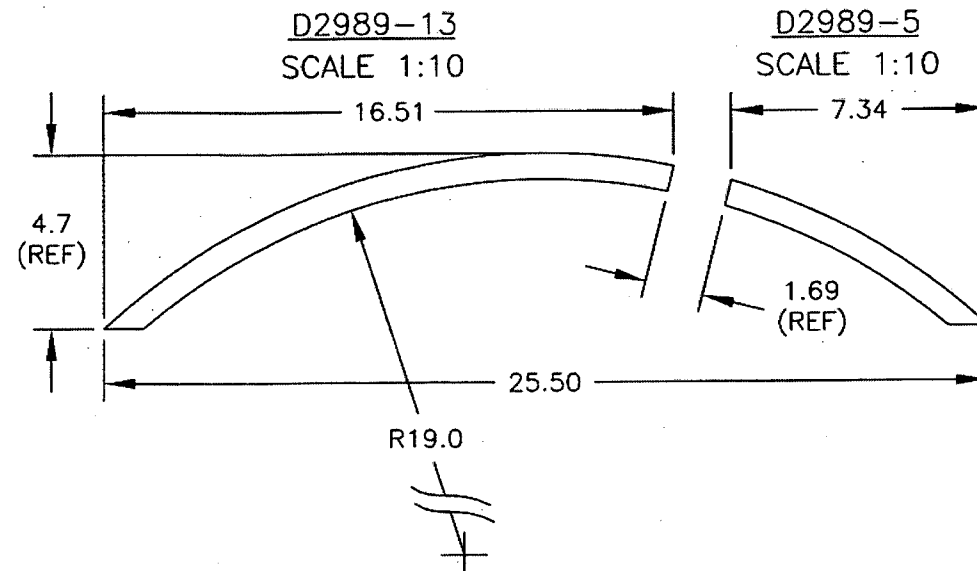
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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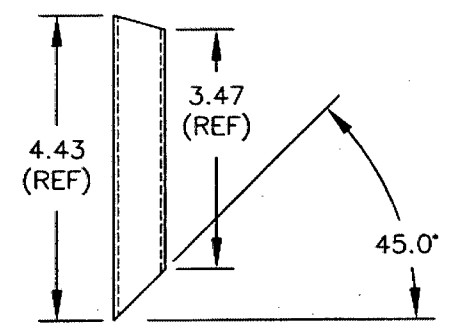
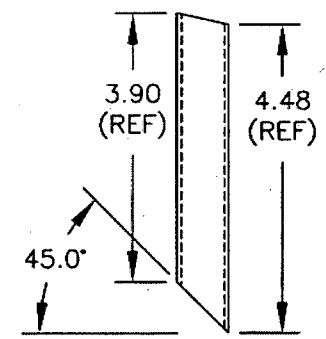
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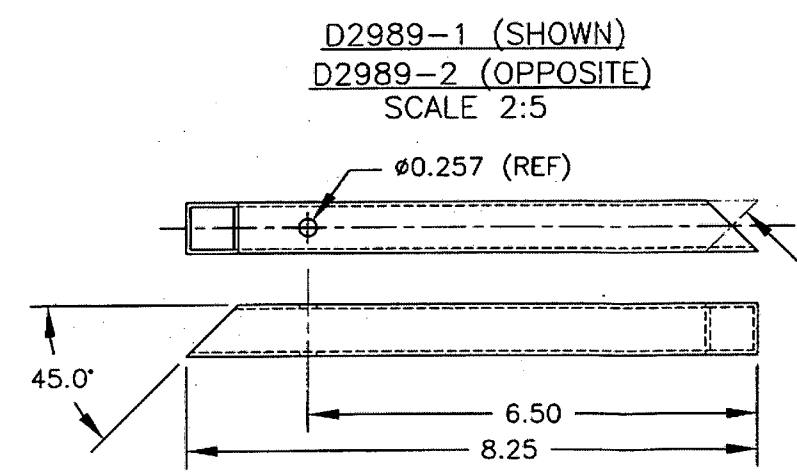
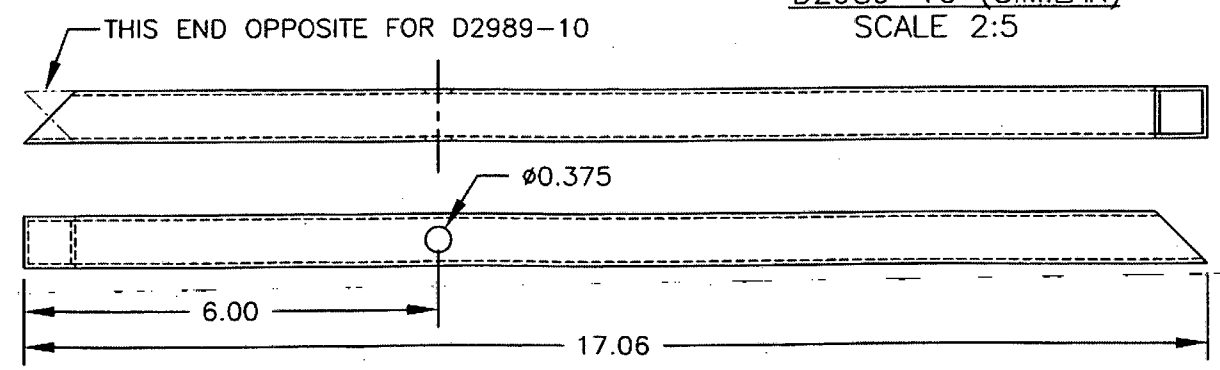


D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5



UNDER REVIEW
08.05.08 PH
TUBING TO BE
CHANGED TO Ø.065
WALL PH
08.05.08

THIS END OPPOSITE
FOR D2989-2

RELEASED
05.08.19

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WORK ORDER
NO. 39131A

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		DATE 05.06.07		DRAWING NO. D2989	SCALE 1:10
				TITLE BASKET LID ASSEMBLY	

Date: Thursday, 08/05/2008 12:37:17 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET BASE ASSEMBLY (350)
Job Number :	39131C		
Estimate Number :	10189		
P.O. Number :		Part Number :	D2221
This Issue :	08/05/2008	Drawing Number :	D2221 W/R D2235
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	08/05/2008	Drawing Revision :	F/B1
Previous Run :	39050C	Material :	
Written By :		Due Date :	24/05/2008
Checked & Approved By :	<u>JLD 08.5.08</u>	Qty:	1 Um: Each
Comment :	Est Rev:J 05.09.02 Added D3442-1KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3166-1 RIB 39048

SAD 08/05/22

2.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 Hinge bracket 336846

Cpl 08-05-26

3.0	D2325	Support Gusset (350 Basket)
-----	-------	-----------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2325 Support Gusset 337443 → 1338741 → 3

Cpl 08-05-26

4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2327-3 Bushing 337541

Cpl 08-05-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 12:37:17 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 39131C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket 337248

Pl 08.05.26

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim 3337615

Pl 08.05.26

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch

39.69 sf M304EX0.75-16F Expanded Metal 21107856

SAD 08/05/23

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: 21107857

SAD

08/05/23

(1)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

SAD

08/05/22

(1)

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

Pl 08.05.27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 08/05/2008 12:37:17 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 39131C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION ✓

PD 08-05-29

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 08-05-29

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1 COAT
8:05
400°
8:45

2 COAT
9:15
400°
9:45

BR 08-05-30 ①

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CB 08/05/30 ②

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/09

Job Completion



mf 08-06-06
C2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

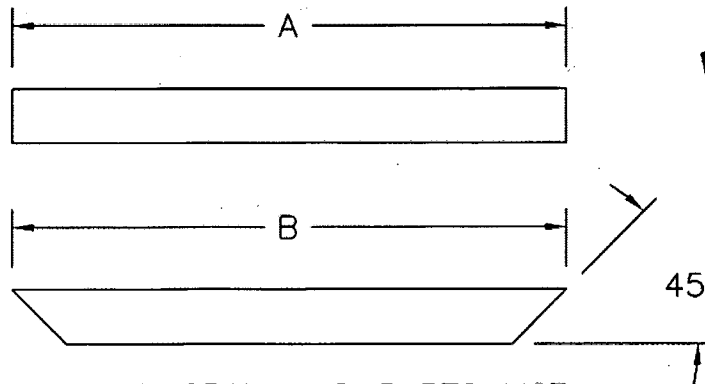
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED05.08.19 *[Signature]***PARTS LIST FOR D2221 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM

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UNDER REVIEW
08.02.05 PH
TUBING TO BE
CHANGED TO 0.065
WALL

D2221-1/-3/-5/-7

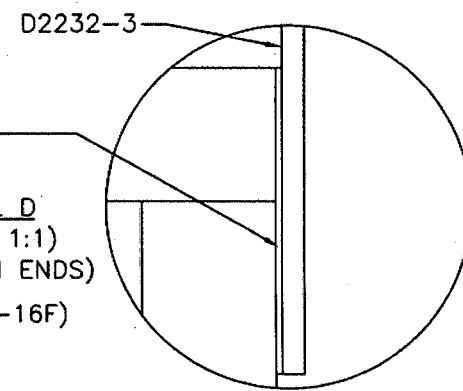
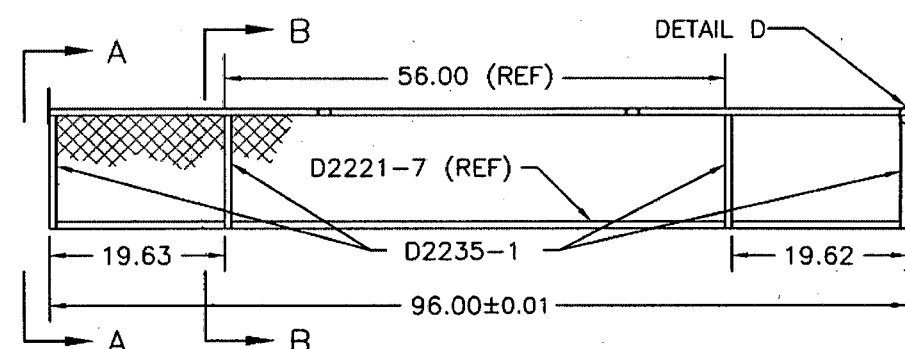
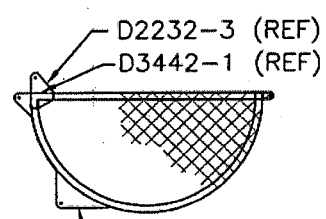
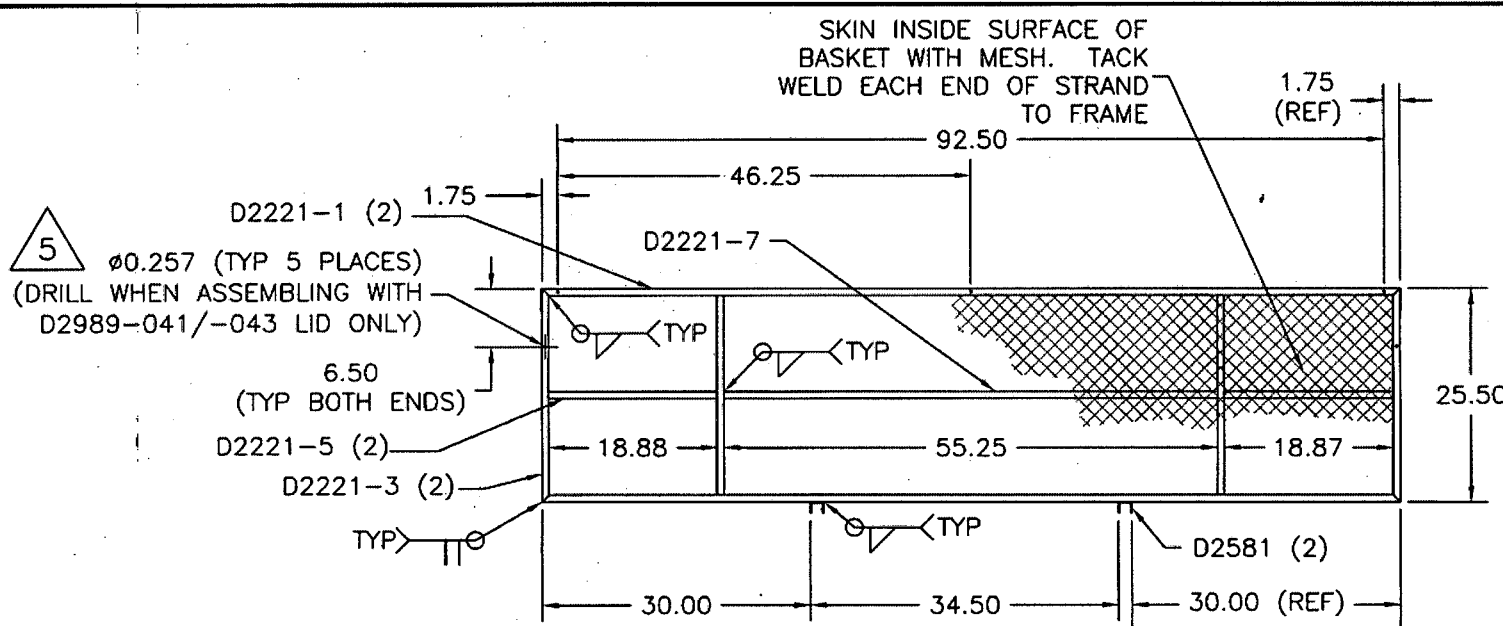
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060) 0.065 *[Signature]* 01.05.08
- 3) TOLERANCES ARE PER DART-QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL $\phi 0.257$ HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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DATE	05.06.07	TITLE	BASKET BASE ASSEMBLY (350)	SCALE	1:20



D2325 (REF)

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NO. 39131C

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05.08.19

UNDER REVIEW
08.05.05
TUBING TO BE
CHANGED TO 0.065
WALL THICKNESS
08.05.08

D2221 BASKET BASE ASSEMBLY

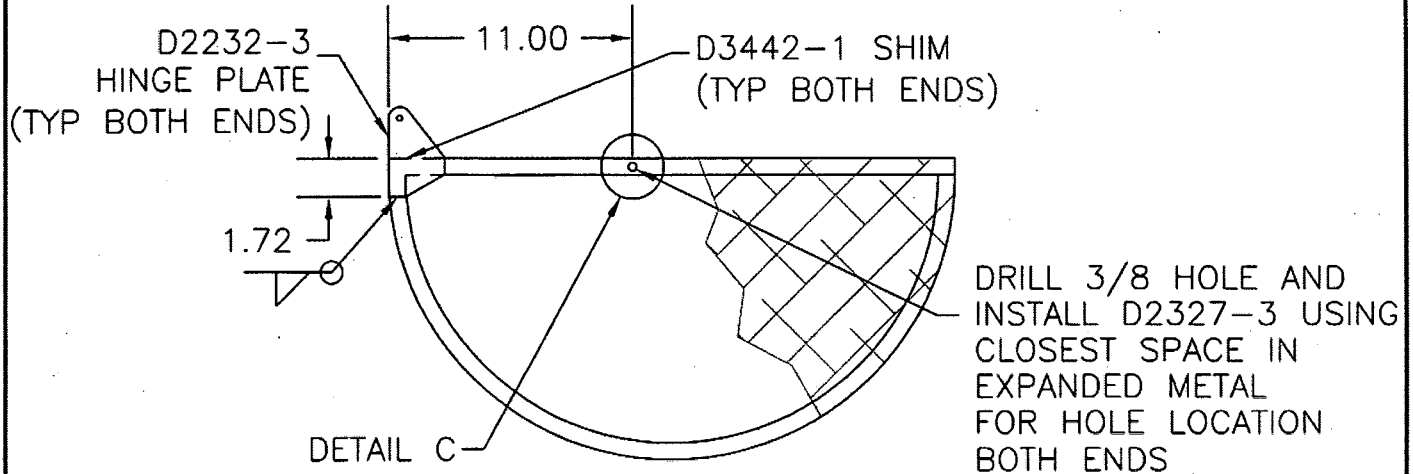
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

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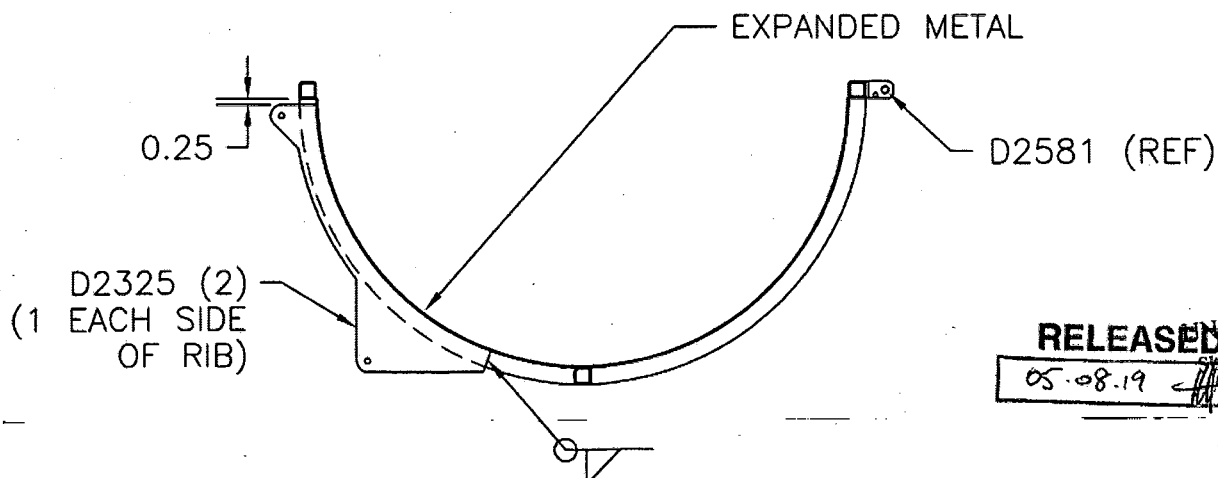
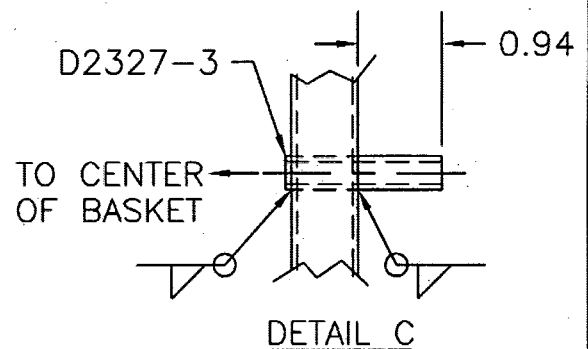
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DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)		SCALE 1:8



SECTION A-A SAME BOTH END RIBS

UNDER REVIEW

08.01.05 PH
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WALL PH
01.05.07



SECTION B-B SAME BOTH CENTER RIBS

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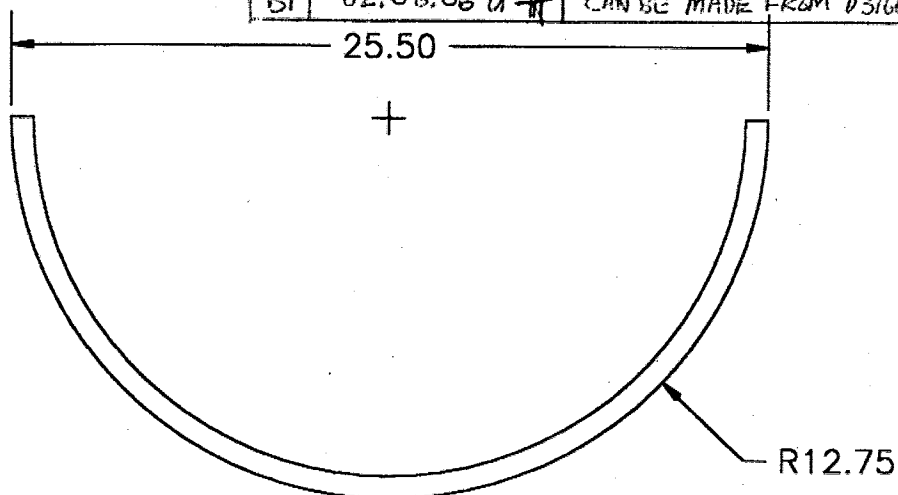
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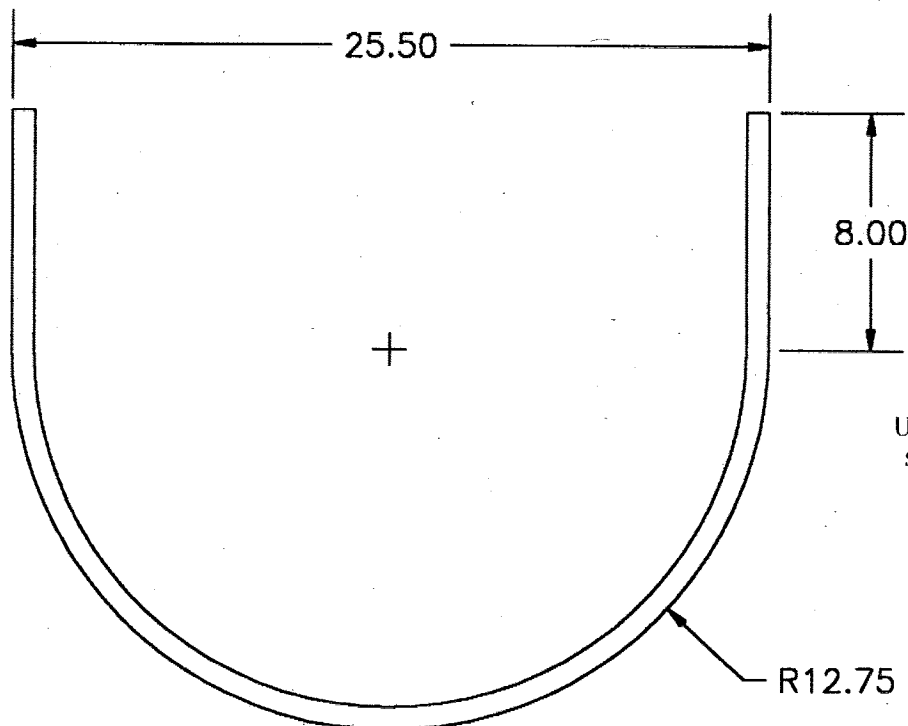


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B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>BW</i>	<i>BW</i>	D2235	SHEET 1 OF 1
DATE		TITLE	SCALE
94:12:16		BASKET RIBS	
BI	02.08.06 <i>U-#</i>	CAN BE MADE FROM D3166-1	

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D2235-1



D2235-3

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